

Shp April 2

Work Order ID 82500

82500

Page 1

March-30-12 3:14:57 PM

Item ID: D4456-5

Accept

N900040100

Setup Start

NS1

Revision ID: PRELIM

Item Name: Center Raingutter

Stop

NS2

Start Date: 3/30/12

Start Qty: 20.00

20

Cust Item ID:

Required Date: 4/02/12

Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4456

A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

B12-3-30

(2)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-3-30

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

5/7/04/02

cut
(x20)

March-30-12 3:14:57 PM

Page 2

Setup Start *NS1*

 Stop *NS2*

Cust Item ID:
Customer:

| | | |
|-----|-------|-------|
| Run | Start | *NR1* |
| | Stop | *NR2* |

[illegible]

Work Order ID 82500***82500***

Page 3

March-30-12 3:14:57 PM

Item ID: D4456-5

Accept

N900040100Setup Start ***NS1***

Revision ID: PRELIM

Stop ***NS2***

Item Name: Center Raingutter

Start Date: 3/30/12 Start Qty: 20.00

20

Cust Item ID:

Required Date: 4/02/12 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

21XØ M-12/04/02

170

Identify as per dwg & Stock Location:

0.00

170

Packaging

Memo

0.00

Packaging

541P20
58241A 1p

16144/2 (21)

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/4/2012

MF
12-04-02

Picklist Print

March-30-12 3:14:56 PM

Page 1

Work Order ID: 82500
Parent Item: D4456-5
Parent Item Name: Center Raingutter

Start Date: 3/30/12
Start Qty: 20.00

Required Date: 4/02/12
Required Qty: 20.00

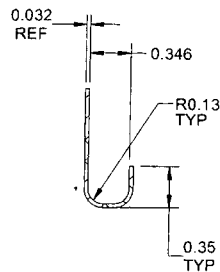
Comments: IPP REV:A 11.11.21 NEW ISSUE DD VERF:EC
DWG REVa DD VERF:EC IPP REV:B 12.01.18 AS PER

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|------------------|--------|
| M6061T6S.032 6061-T6 Sheet 0.032" | | Purchased | No | | | 100 | sf | 318.0560 | 0.5 | 10.526316 | | 11. 1812-3-30 | |

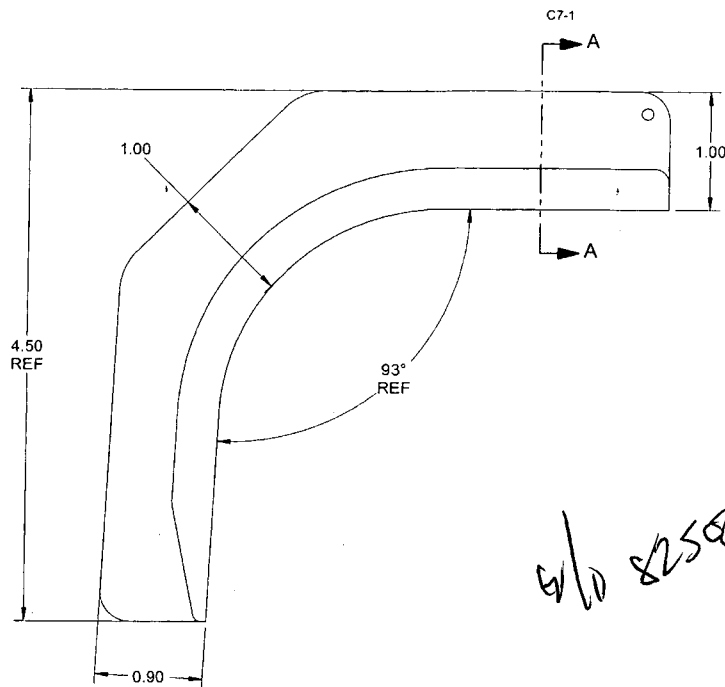
| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| MAT021 | 318.056 | |
| 118106 | 48.606 | |
| 120218 | 33.77 | |
| 120285 | 43.68 | |
| 121099 | 192 | |

121099

21



SECTION A-A D4-1



D4456-1 FWD RAINGUTTER, LH

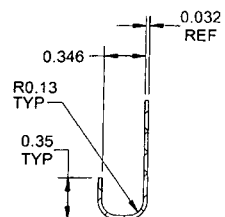
NOTES:

- 1) MATERIAL: MAKE FROM D4456-1F FLAT PATTERN
HEAT TREAT TO 6061-T6 CONDITION AFTER FORMING
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs
- 8) TRIM TABS ON THE HIDDEN LINES AFTER FORMING

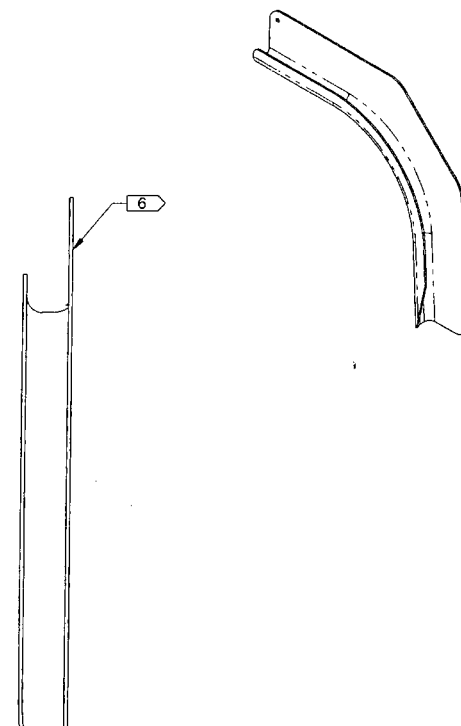
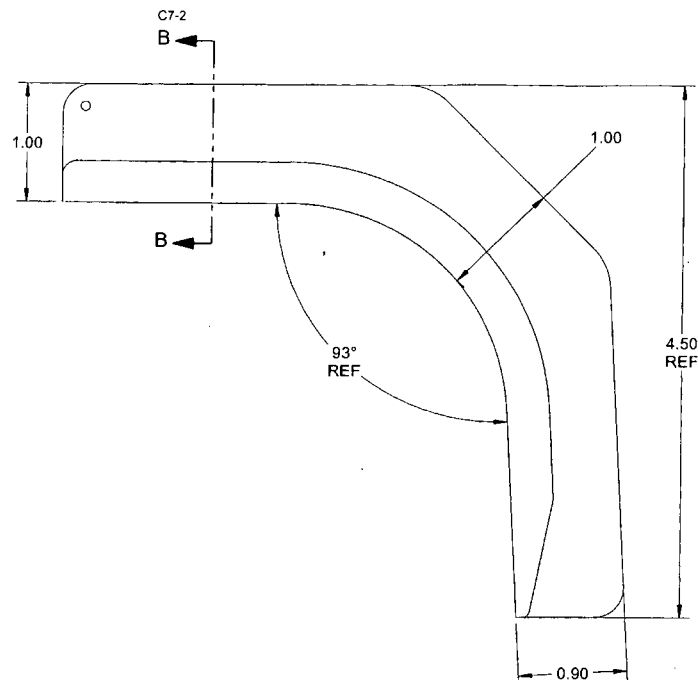
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8 7 6 5 4 3 2 1



SECTION B-B D6-2



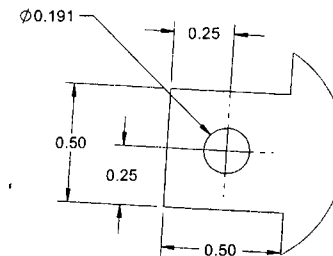
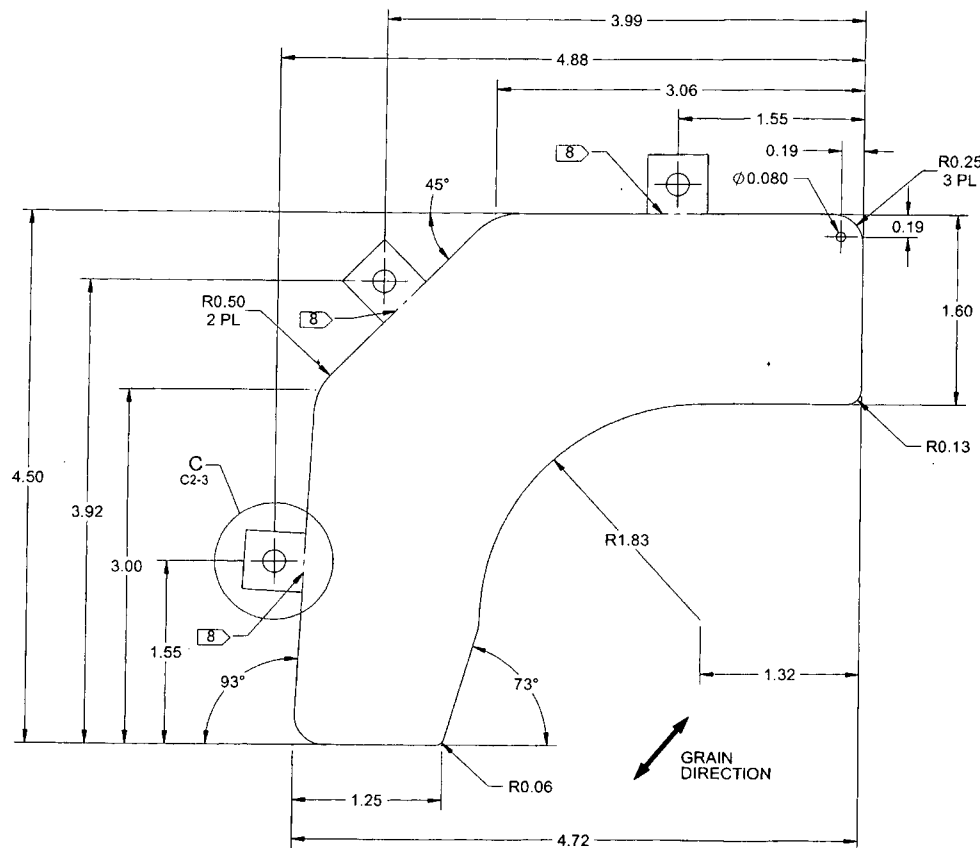
D4456-2 FWD RAINGUTTER, RH

- NOTES:**
- 1) MATERIAL: MAKE FROM D4456-1F FLAT PATTERN
HEAT TREAT TO 6061-T6 CONDITION AFTER FORMING
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.03 lbs
 - 8) TRIM TABS ON THE HIDDEN LINES AFTER FORMING

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| DE APPR. | <i>[Signature]</i> | FWD RAINGUTTER, RH | 1:1 |
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8 7 6 5 4 3 2 1



DETAIL C C7-3
TYP C6-3
D5-3

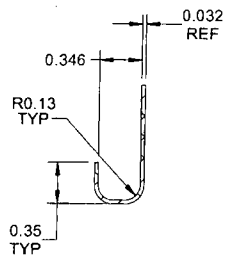
D4456-1F FWD RAINGUTTER FLAT PATTERN

NOTES:

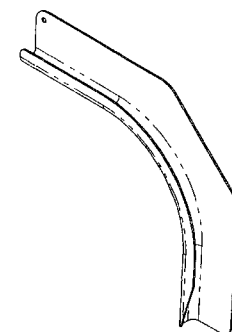
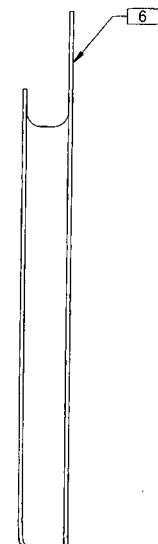
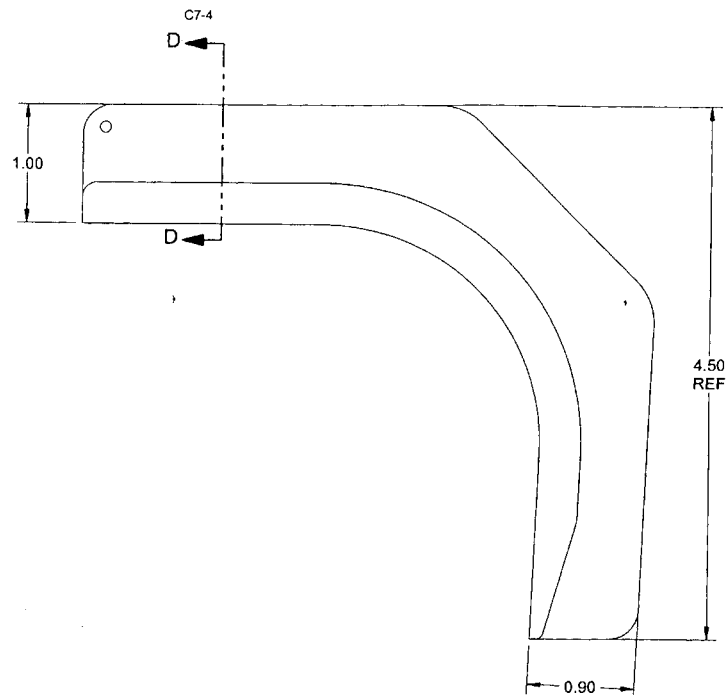
- 1) MATERIAL: 6061-O ALUMINUM SHEET 0.032 THICK
PER AMS QQ-A-250/11 OR AMS 4025
REF DART SPEC M6061-OS.032
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

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SECTION D-D C6-4



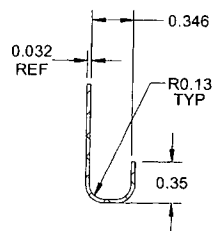
D4456-3 AFT RAINGUTTER, LH

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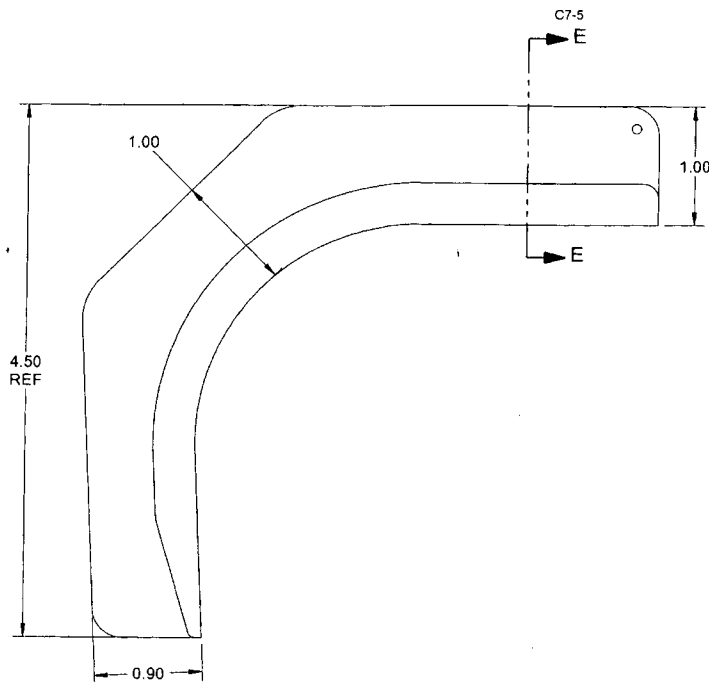
NOTES:

- 1) MATERIAL: MAKE FROM D4456-3F FLAT PATTERN
HEAT TREAT TO 6061-T6 CONDITION AFTER FORMING
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs
- 8) TRIM TABS ON THE HIDDEN LINES AFTER FORMING

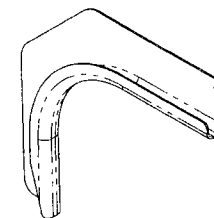
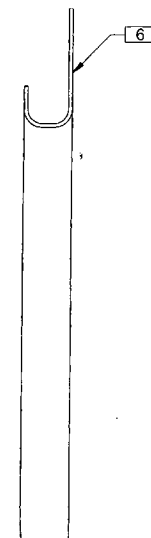
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SECTION E-E D4-5



D4456-4 AFT RAINGUTTER, RH

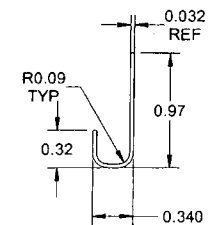
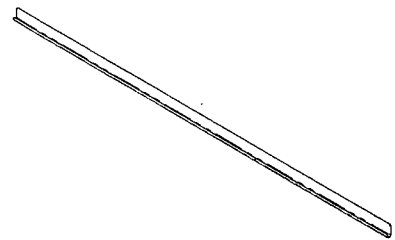
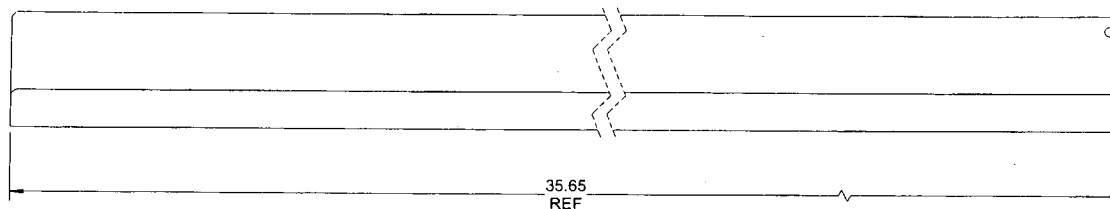


NOTES:

- 1) MATERIAL: MAKE FROM D4456-3F FLAT PATTERN
HEAT TREAT TO 6061-T6 CONDITION AFTER FORMING
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs
- 8) TRIM TABS ON THE HIDDEN LINES AFTER FORMING

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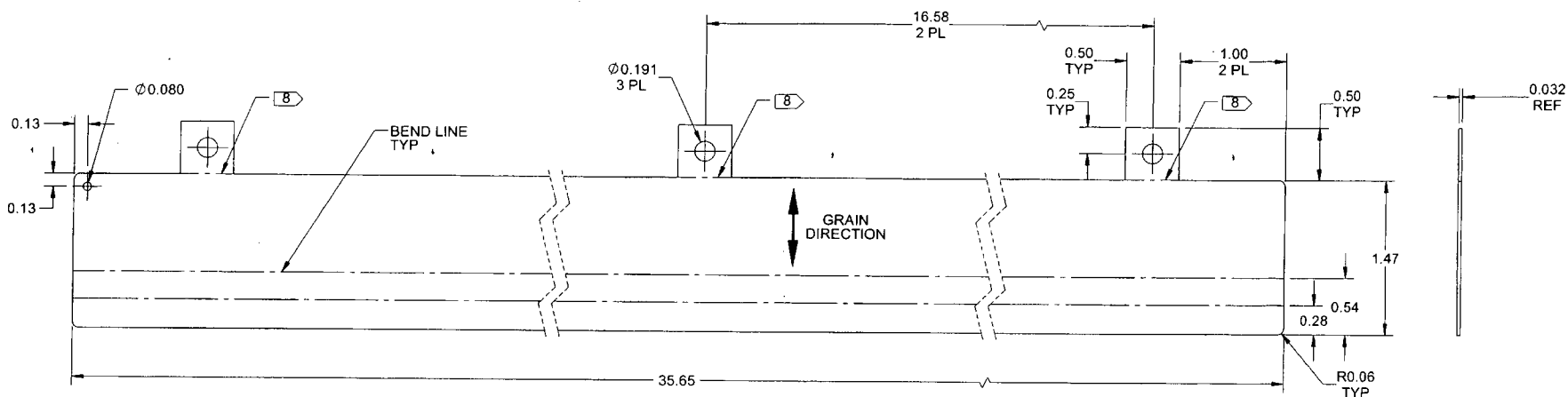
D4456-5 CENTER RAINGUTTER

RELEASED
2012-01-17

NOTES:

- 1) MATERIAL: MAKE FROM D4456-5F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.17 lbs
- 8) TRIM TABS ON THE HIDDEN LINES AFTER FORMING

| | | | |
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D4456-5F CENTER RAINGUTTER FLAT PATTERN

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NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.032 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.032
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.17 lbs

| | | | |
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